

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 10/25/2006 11:14:04 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 29161	
Estimate Number : 10533	
P.O. Number : NIA	Part Number : D2573
This Issue : 10/25/2006 S.O. No. : NIA	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 28804	Material : NIA
Written By : <u>[Signature]</u>	Due Date : 11/15/2006
Checked & Approved By : <u>[Signature]</u>	Qty: 4 Um: Each
Comment : Est: 1 As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B25354 x4

En 06/10/28

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No: B29161 Double check by: [Signature]

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

En 06/10/30 x4

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

En 06/10/30 x4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

En 06/10/30 x4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:14:04 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 29161

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

and 06/10/30

4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06/11/10

(4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

GREEN

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M18144

yl a.m 06/11/15 x4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

LB 06/11/16 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57480

LB 06/11/16 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/16

Job Completion



06/11/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29161
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.442	0.442	0.442	0.442		
B	1.745	1.755		1.747	1.751	1.751	1.747		
C	3.495	3.505		3.501	3.500	3.499	3.498		
D	1.745	1.755		1.749	1.751	1.751	1.747		
E	7.990	8.010		8.000	8.004	8.004	8.006		
F	0.490	0.510		0.496	0.500	0.498	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.503	0.502	0.500		
J	1.174	1.184		1.175	1.178	1.177	1.176		
K	0.558	0.578		0.561	0.568	0.568	0.568		
L	1.174	1.184		1.175	1.178	1.177	1.176		
M	1.365	1.375		1.368	1.371	1.370	1.369		
N	2.495	2.505		2.497	2.499	2.499	2.501		
O	4.119	4.129		4.121	4.122	4.122	4.120		
P	0.115	0.135		0.127	0.129	0.128	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.256	0.255	0.255	0.256		
S	0.115	0.135		0.123	0.123	0.120	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.234	0.240	0.240	0.244		
W	0.115	0.135		0.124	0.121	0.121	0.123		
X	0.308	0.313		0.311	0.310	0.310	0.316		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.370	0.364	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.625	0.628	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.250	0.249	0.248		
AE	1.500	1.520		1.512	1.515	1.513	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.252	0.252	0.257		
AI	2.000	2.020		2.003	2.004	2.003	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

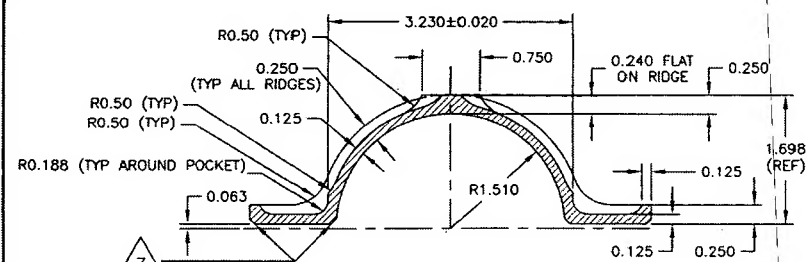
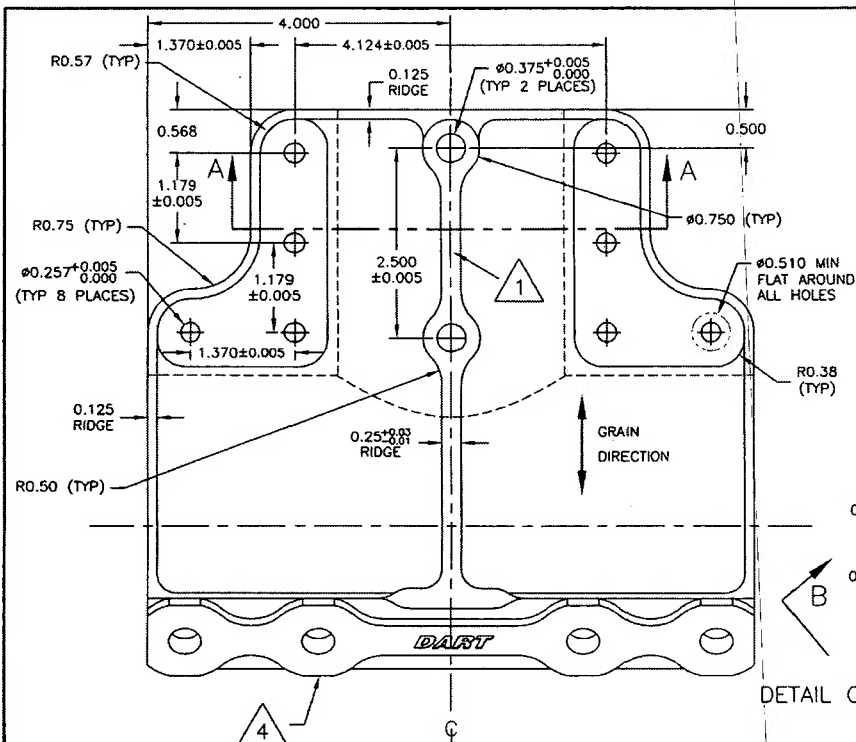
Measured by:	ES
Date:	06/10/30

Audited by:	mf
Date:	06/10/30

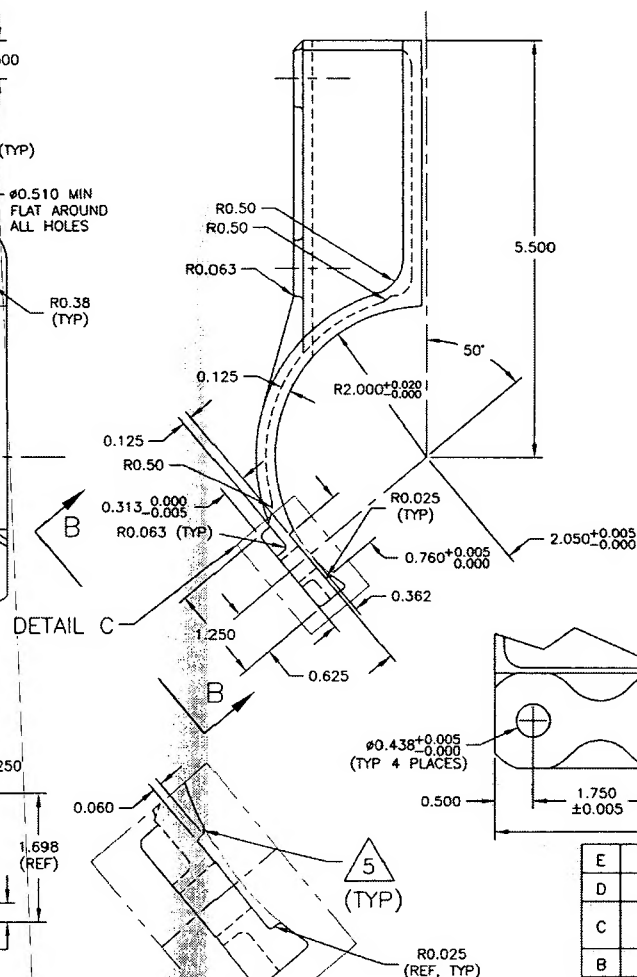
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06 #



SECTION A-A

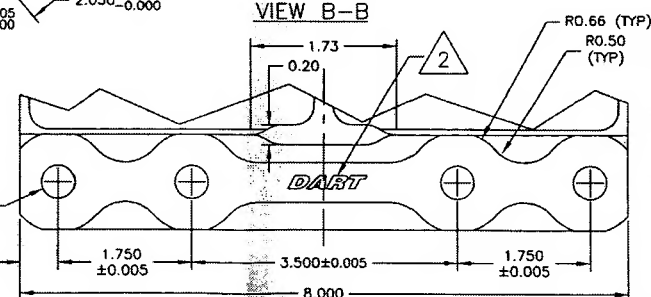
DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4 CHAMFER 0.063" x 45° ALL AROUND
5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E	SHEET 1 OF 1
				SCALE	2:3

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